

5/15

DART AEROSPACE LTD	Work Order:	22597
Description: Window Assembly	Part Number:	D3136-043
<i>04.06.09</i>		
Dwg: D3136 Rev. <i>B/C</i>	Qty:	20
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	<i>KJ</i>	05.03.02	20
2	PG	Issue P/O: <i>2007674</i> Order D3136-3 per Dwg D3136 Supplier: -Canus Material: Polycast II Clear Acrylic sheet per MIL-P-5425 0.125" thick Apply 3M Protective Masking Film both sides Material release note required	<i>U</i>	05.03.02	20
3	RG	Receive and Inspect for transit damage Ensure that material release note is attached	<i>CL</i>	05/04/27	20
4	QC6	Inspect dimensions as per Dwg D3136	<i>U</i>	05.05.05	20
5	GA	Trim back masking film as per Dwg D3136 and apply D3108-9 decals to inside surface of windows. D3108-9 Batch: <i>B22608</i>	<i>SB</i>	05/05/17	20
6	GA	Engrave Part number and Batch number as per Dwg D3136	<i>SB</i>	05/05/17	20
7	QC5	Inspect work to Step 6	<i>2</i>	05.05.18	20
8	ST	Identify and Stock as D3136-043	<i>CL</i>	05/05/18	20
9	AC	Cost / part <i>57.19</i>	<i>Syc</i>	05.05.19	20
10	DC	Close W/O <i>57.19</i> Inspect Level 21	<i>KJ</i>	05.06.02	20

Rev	Date	Change	Revised By	Approved
A	04.02.04	New issue	KJ/DS	<i>[Signature]</i>

RELEASED
04.02.04

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
05-05-17	6	Add dimension to DWG 3136 for for engraving part & batch #'s, Also AS per template for consistency Permanent Change <i>J</i>	<i>[Signature]</i>	05.06.02	N/A	U	<i>2</i> 05-05-17	
05-05-17	5	Add template 03136- 374 to step for reference to Apply decals. <i>Record in tooling Book</i> Permanent change <i>J</i>	<i>[Signature]</i>	05.06.02	N/A	U	<i>2</i> 05-05-17	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
				See NCR 879				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

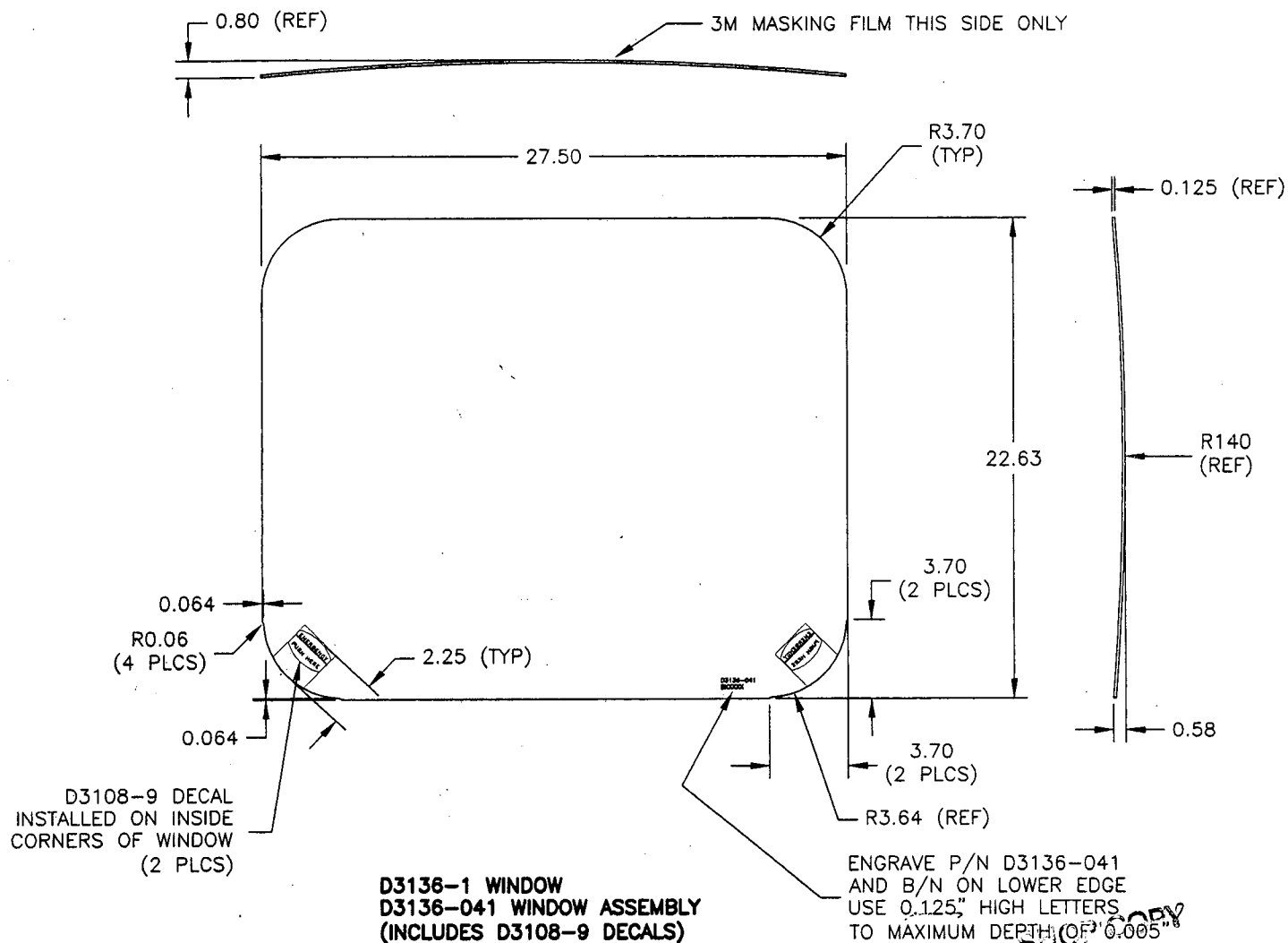
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN	<i>[Signature]</i>	DRAWN BY	<i>[Signature]</i>	DART AEROSPACE LTD	REV. C
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3136	SHEET 1 OF 2
DATE	04.05.05	TITLE	WINDOW ASSEMBLY	SCALE	1:8
A	02.04.18	NEW ISSUE			
B	04.01.21	ADDED D3136-3 AND D3136-043			
C	04.05.05	ADDED FORMING & ENGRAVING SPEC			

RELEASED
04.05.12 *[Signature]*



NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET FER MIL-P-5425 0.125 THICK
- 2) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F
b) DRAPE OVER D3136-T1 MOLD & CLAMP
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS
d) TRIM PER TEMPLATE D3136-1T2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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NO. 22597

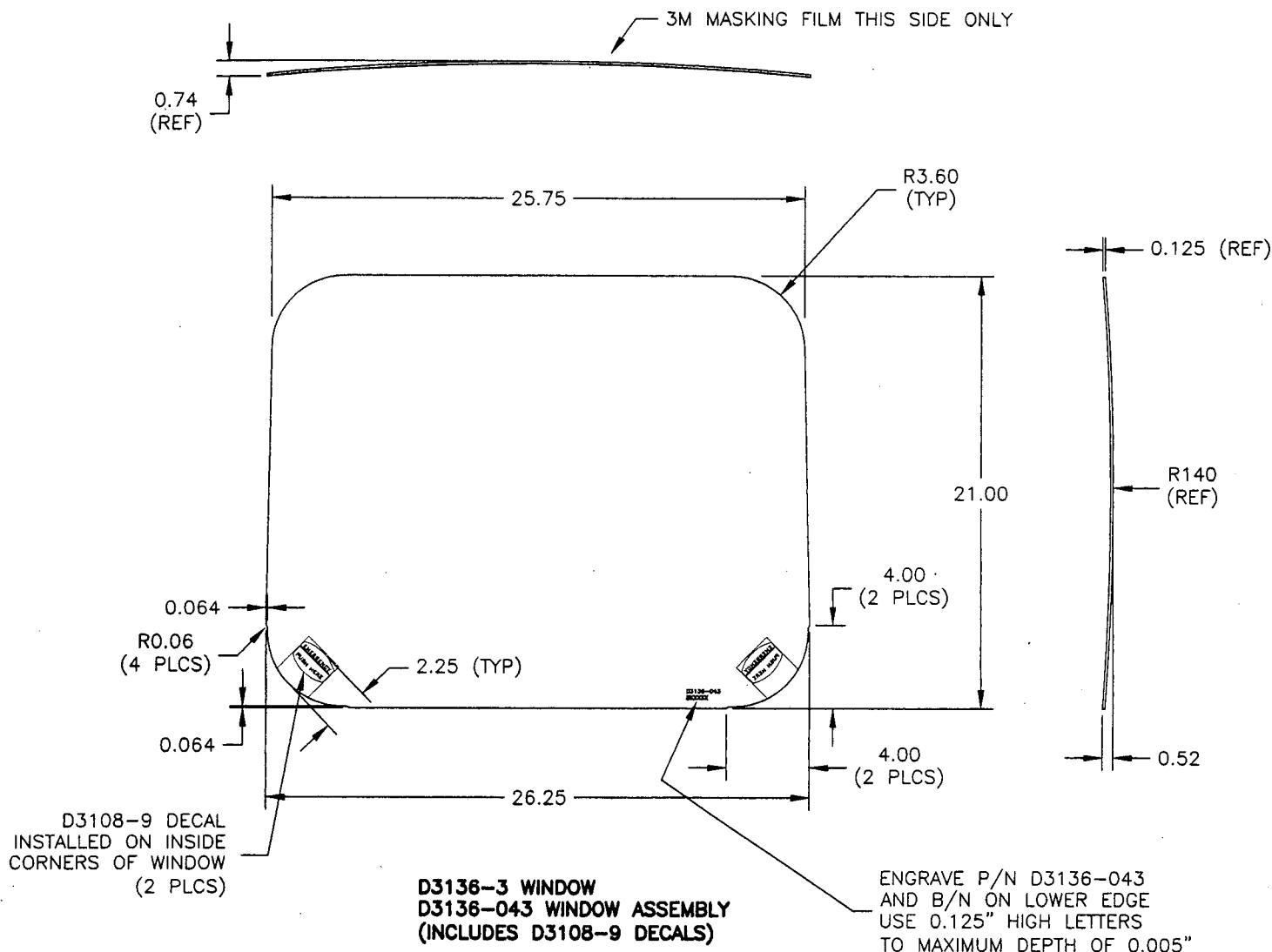
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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3136	REV. C SHEET 2 OF 2
DATE 04.05.05		TITLE WINDOW ASSEMBLY	SCALE 1:8

RELEASED
04.05.12 *[Signature]*



NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET FER MIL-P-5425 0.125 THICK
- 2) FORMING PROCESS:
 - a) HEAT LARGER PIECE TO 250° F
 - b) DRAPE OVER D3136-T1 MOLD & CLAMP
 - c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS
 - d) TRIM PER TEMPLATE D3136-3T1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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DATE: 04.05.12
BY: [Signature]

ORDER
NO. 22597

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Mar 01, 2005
11:19 am

Work Order No : 0022597
Project Name : D3136-043
Project For : WK515
Work Order Type : Main
Main WO Number :
House Part Number : D3136-043
Description : Window Assembly
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 03-01-05
Est Finish Date : 03-30-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Laird Plastics
VALUE THROUGH SERVICE™*Attn: Linda
From: Don @ Canus*CERTIFICATE OF CONFORMANCE

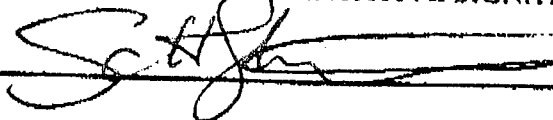
SOLD TO Canus Plastics
DATE 04/19/05
YOUR PURCHASE ORDER NUMBER Rob
LINE NUMBER THE ITEM IS ON 1
QUANTITY 3
DESCRIPTION OF ITEM .177 x 48 x 96 clear plexiglas G
MANUFACTURED BY Arkema Corp.

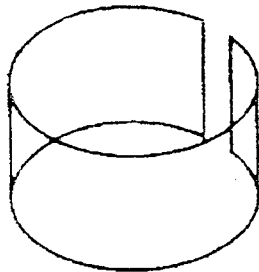
THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH

Tech Data Sheets

This is to certify that the material finishes and functional requirements of the above listed parts are in accordance with the reference procurement specifications, control drawings, or parts designation and latest revisions as referenced on the subject purchase order.

AUTHORIZED REPRESENTATIVE SIGNATURE(S)





CANUS Plastics Inc.
300 Lisgar Street,
Ottawa, Ontario, Canada
K2P 0E2

Telephone (613) 232-2657

CERTIFICATE OF CONFORMANCE

Attention: Receiving Inspection

TO 2 Part Aerospace Ltd

Date: April 25/05
P.O # 2007674
Packing slip # 115617

The undersigned hereby certifies that the materials supplied and the items shipped herewith under the above purchase order and on the packing slip are in conformance with all contractual applicable government specifications and/or purchase order requirements and that physical and/or chemical reports of the materials supplied are on file and will be made available to the buyer and Government upon request.

QUANTITY

20

DESCRIPTION

Window
1 D3136-3

SPECIFICATION #.

1/8" Clear Cast
Pluxiglass-G

CANUS PLASTICS INC.

Donald P. [Signature]